

Work Order ID 128887

128887

Page 1

Tuesday, January 27, 2015 7:53:18 AM

Item ID: D4753-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Doubler
 Start Date: 1/21/15 Start Qty: 60.00 *60* Cust Item ID:
 Required Date: 1/26/15 Req'd Qty: 60.00 *60* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 15-01-29 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4753	A

100 FLOW WATER JET 0.00 60 0 Jan 15-2-10

100

Waterjet

FLOW CNC Waterjet

6061.125

Memo

1-Cut as per Dwg D4753

Dwg Rev: A

Prog Rev: A

***.758" DIA HOLE TO BE OPENED TO FIN SIZE BY SKID DEPARTMENT
 UPON INSTALLATION**

3- Deburr if necessary

110 QC2- Inspect parts off machine FAI/FAIB 0.00

110

QC

Quality Control

Memo

0.00

60 0 Jan 15-2-10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
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Stop ***NR2***

**Insp.
Stamp**

0.00

Small Fab

0.00

Small Fab

Memo

Small Fab

C'sink as per Dwg D4753
(On Flat side)

160

QC5- Inspect part completeness to step on W/O

0.00

0.00

QC

Memo

Quality Control

170

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

HandFinish

Memo

Hand Finishing

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Work Order ID 128887

128887

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Tuesday, January 27, 2015 7:53:18 AM

Item ID: D4753-1 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Doubler

Start Date: 1/21/15 Start Qty: 60.00 *60* Cust Item ID:

Required Date: 1/26/15 Req'd Qty: 60.00 *60* Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC7-Inspect Chemical Conversion Coat	0.00							DAS 38 9-89
180									
QC	Memo	0.00							
Quality Control									
190	Identify as per dwg & Stock Location. <u>LC or</u>	0.00							
190									
Packaging	Memo	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

FEB 24 2015

FEB 26 2015

DAS
66
3-89

60

MC 1508 26

Dis. 2-26

DQA: _____ Date: _____



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Picklist Print

Page 1

Tuesday, January 27, 2015 7:53:17 AM

Work Order ID: 128887

128887

Parent Item: D4753-1

D4753-1

Parent Item Name: Doubler

Start Date: 1/21/15

Required Date: 1/26/15

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP REV:A NEW ISSUE 13-02-21 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased		No			sf	131.5395		1			

M6061T6S 125

6061-T6 .125 Sheet

Jm 5-2-10

Location

Loc Qty

Loc Code

MAT020

131.53945

m127454

2.25

m130745

33.28945

m131352

96

131352

H:\FORMS\DO

DQA: _____ Date: _____



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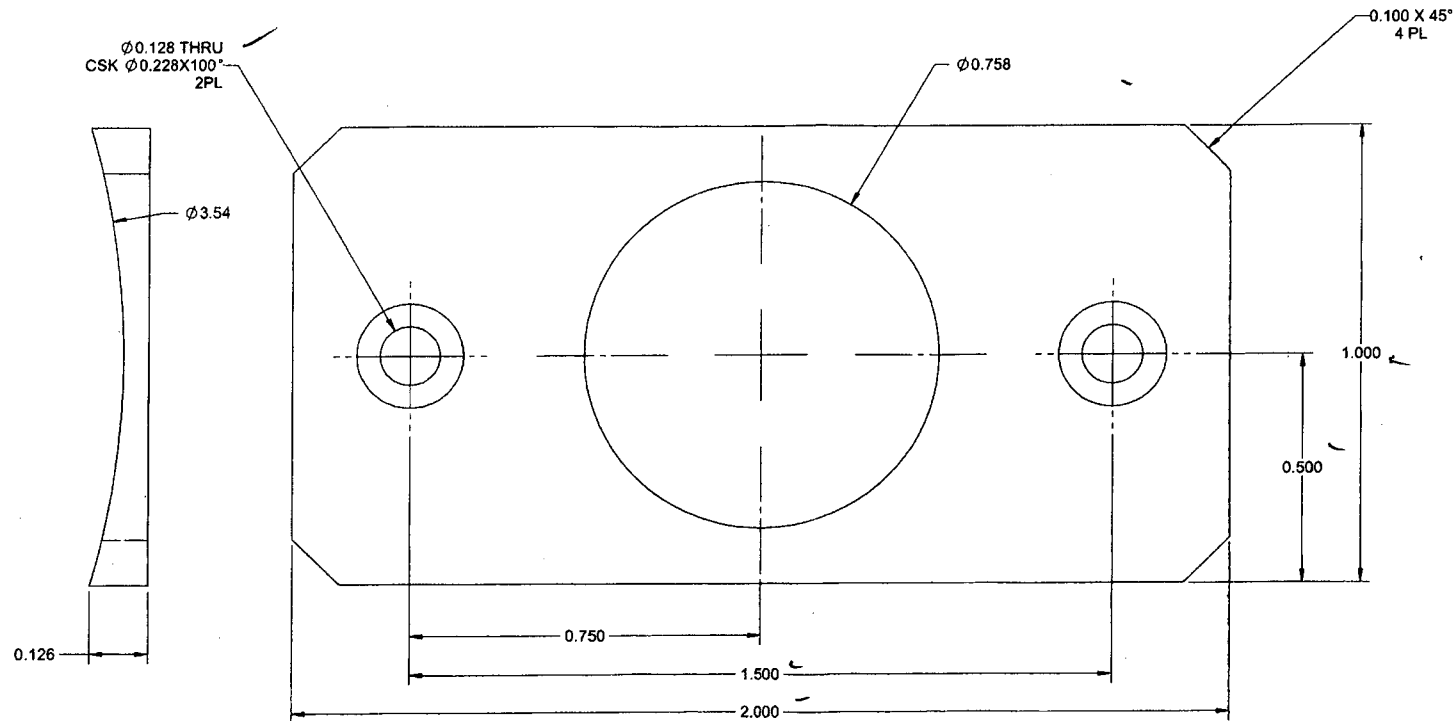
8 7 6 5 4 3 2 1

D

C

B

A



128887
MLJ
150129

D4753-1 DOUBLER

RELEASED
2013-03-25
WJ

NOTES:

- 1) MATERIAL: 6061-T6/T651 ALUMINUM PER QQ-A-250/11
REF DART SPEC M6061T6S
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4753-1" AND B/N PER QSI 044 METHOD 6.7
- 7) WEIGHT: 0.01 lbs

A	NEW ISSUE	AP	13.02.13
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AP		
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	AP	D4753	SHEET 1 OF 1
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	DOUBLER	NTS
DATE	13.02.13	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1